

Date: Monday, 2/25/2008 7:33:59 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLEVIS  
 Job Number : 37583  
 Estimate Number : 10773  
 P.O. Number :  
 This Issue : 2/25/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D33481  
 First Issue : 11 Type : SMALL /MED FAB Drawing Number : D3348 REV. B  
 Previous Run : 32848 Drawing Revision : B  
 Written By :  
 Checked & Approved By : 08 02.25  
 Comment : Est: A 05.02.09 New issue KJ/JLM Material :  
 Due Date : 3/5/2008 Qty: 40 Um: Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

Machine Number:

M1010S12GA

1010/1025/A21/6aA SHEET

Job Number:



Job Issue:

Job Rev:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Comment: Qty.: 0.0191 sf(s)/Unit Total: 0.7644 sf(s)

1010/1025/A21/6aA SHEET

(M1010S12GA) .105" THK

Batch: 104288

IB 8-2-25

Job Issue:

Job Issue:

Job Issue:

Job Issue:

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Job Issue:

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3348

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

IB 8-2-25

(43)

08/02/27 Hm (43)

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Comment: SECOND CHECK

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Job Issue:

Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: FD Date: 08/03/07

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 7:33:59 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 37583

Part Number: D33481

Job Number:



Seq: #

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3348

SB 08/03/06 (43)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 (43)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Dual

8/3/06

50

(43)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

Job Completion



2008/3/07

(43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

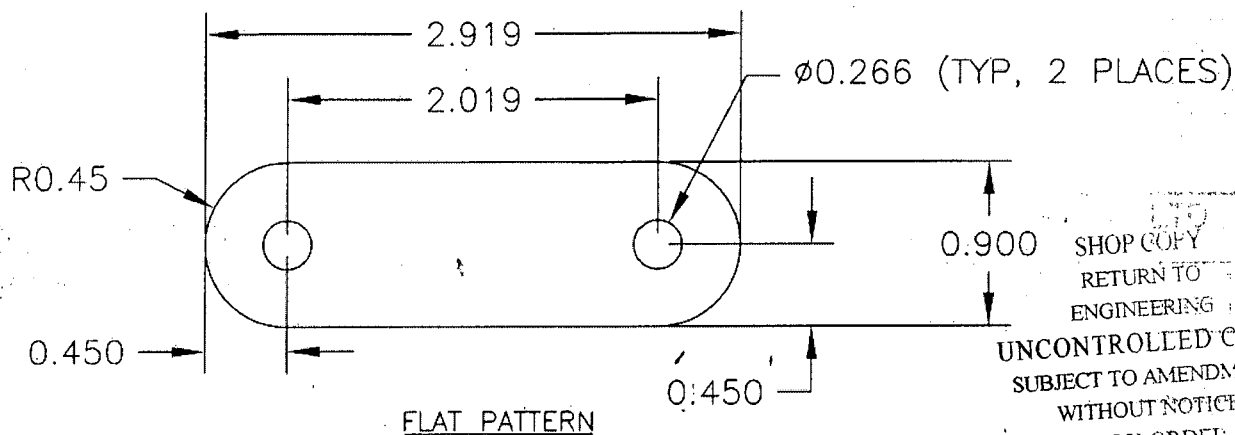
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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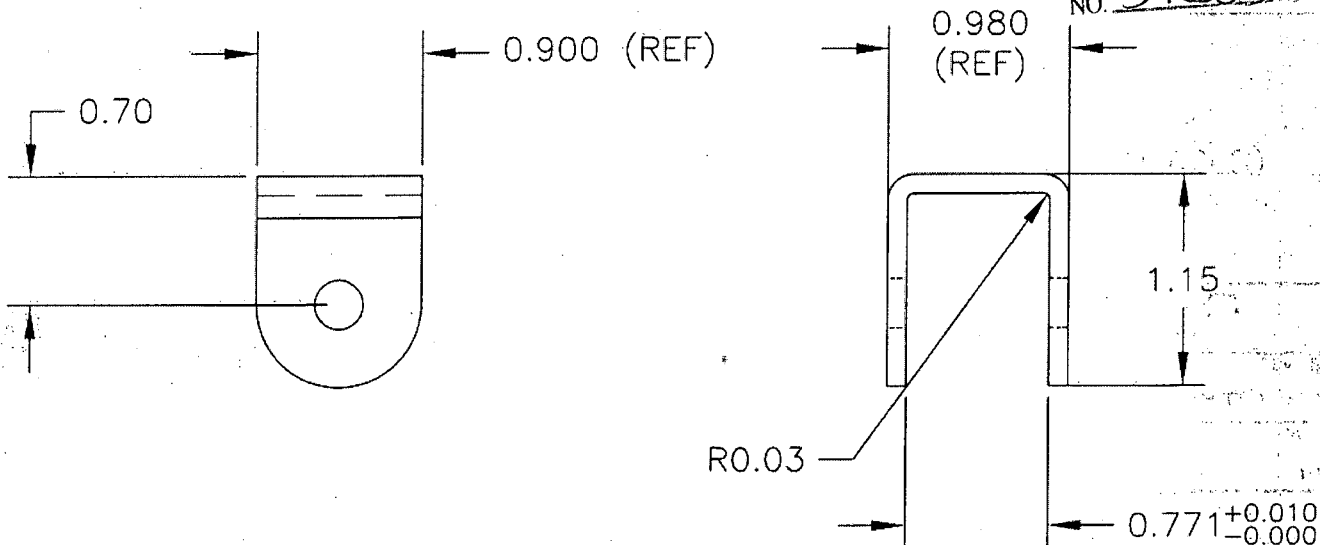


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3348	REV. B SHEET 1 OF 1
DATE 05.03.04		TITLE CLEVIS	SCALE 1:1
A	04.11.11	NEW ISSUE	
B	05.03.04	INSIDE RADIUS WAS R0.13, NOW R0.03	

RELEASED  
05 03 05



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31583



BENDING DETAIL

D3348-1 CLEVIS

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR  
CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 12 GAUGE (0.105 THICK)  
(REF DART SPEC. M1010-S12GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

